

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021248**Date Inspected:** 07-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

**OBG Segment 12BE**

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality assurance personnel performing Ultrasonic Testing (UT) on Bottom Panel longitudinal weld after repair. Weld # SEG3002A-003. See attached photograph Pic\_001.

**OBG Segment 12CW**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # CA3012-203 of Counterweight side Drain Plate. The welder is identified as 037723. ZPMC CWI is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1. See attached photograph Pic\_002.

**OBG Segment 12BE Tagging**

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## WELDING INSPECTION REPORT

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This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as Bottom Panel longitudinal weld after repair as per ZPMC notification # 07261, item # 3.

The weld designations reviewed are as follows:

SEG3002A-003

Bay 14 / OBG Segment 14E

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as Bottom Panel longitudinal welds as per ZPMC notification # 07263.

The weld designations reviewed are as follows:

SEG3019A-002, 003, 014



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer